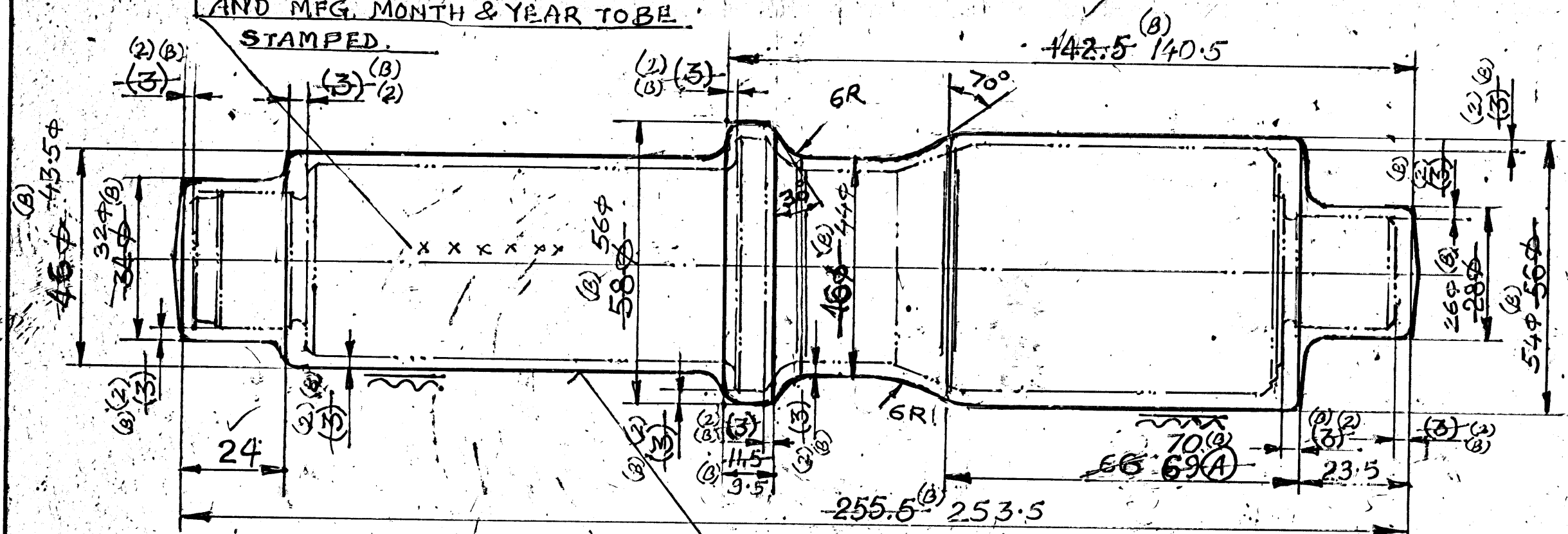


DRG. NO. \_\_\_\_\_ SUPPLIER INITIAL \_\_\_\_\_  
 AND MFG. MONTH & YEAR TO BE  
 STAMPED.

ALL DIMENSIONS ARE M.M.



INSPECTOR WILL DEFACE HERE IN  
 CASE THE FORGING IS FOUND REJECTABLE.

NOTE (B) ALL DIAS. SHOULD BE  
 CONCENTRIC W.R.T. CENTRE LINE  
 WITHIN 0.5 M.M.

(B) 140-187 BHN  
 HARDNESS: -170-217 BHN (R)

- NOTE:-
- FORGING RIDGES TO BE TRIMMED CLEAN & SMOOTH FINISH, ALLOWER.
  - FORGING TO BE SHOT BLASTED.
  - FORGING TO BE COATED WITH RED OXIDE PRIMER TO ISS: 3-47-13 BY BRUSHING OR SPRAYING.
  - SAMPLE TO BE APPROVED BEFORE BUCK SUPPLY.
  - DIM. IN BRACKET INDICATES MACHINING ALLOWANCE.
  - STEEL SHOULD BE FREE FROM CENTRE SEGREGATION PIPING FLAKES ETC.
  - DRAFT ANGLE - 5°.
  - UNSPECIFIED RADII - 2.5R.
  - STAMPING FACE & STOP FACE FOR 1<sup>ST</sup> MACHINING OPERATION.

MATL.	20 Mn Cr 5 E	EQT. MATL.	
CHEMICAL COMPOSITION IN %			
(B) 140-187 BHN 150-THERMAL ANNEAL			
HEAT-TREATMENT: - NORMALISED			
HARDNESS: - 150-260 BHN (B)			
MICRO-STRUCTURE: FINE PERRITE & PEARLITE			
GRAIN SIZE: - ASTM 5 OR FINER			
INCLUSION RATING: 3 ABCD THIN SERIES OR FINER AS PER IS: 4163			
1987. STEEL SHOULD NOT HAVE ANY LARGE INCLUSIONS OR A CONGLOMERATION OF INCLUSION.			

FORGING TOL. AS PER IS: 3469-74							
FORGING WEIGHT	ENVELOP WEIGHT	COMPLE. XITY.	INTRAC. OF MATL.	FORGING GRADE			
3.3 kg	5.27 kg	S <sub>2</sub>	M <sub>1</sub>	NORMAL			
KIND OF DIM.	TOL.	KIND OF DIM.	TOL.				
LENGTH	+2.1 -1.1	RESIDUAL FLAT	+1				
DIA	+1.5 -0.7	TRIMMED FLAT	-1				
MISMATCH	0.8	ANGULAR	+20 -10				
STRAIGHTNESS	1.1	RADII.	+50% -25%				
INTERNAL DIMS. REVERSE SIGN. + & -							

(R)	HARDNESS 140-187 BHN WAS 170-217 BHN CHANGE AS PER CORRESPONDING T.S. 50-65 INDICATED IN M/S TELCO FORGING DRG. NO. 322-283-0605-50. K.P. 29/11	12-10-02	DGM/ITM R. 19/10 JWM/FDD
(B)	DIM. 43.5φ WAS 46φ, 56φ WAS 58φ, 44φ WAS 46φ, 26φ WAS 28φ, 54φ WAS 56φ, 32φ WAS 34φ, 253.5 WAS 255.5, 70 WAS 69, 9.5 WAS 11.5, 140.5 WAS 142.5, MECH. ALLOW. (2) WAS (3), CONCENTRICITY NOTE ADDED. H.T. 150-THERMAL ANNEAL WAS NORMALISED, HARDNESS 170-217 BHN WAS 150-260 BHN CHANGE AS PER SHOP REQUIREMENT. 2. DIM STD. K.P. 29/11		W.M. ITM R. 12/3/0 JWM/FDD JWM/ES 7.3.01
(A)	IN NOMENCLATURE DRIVESHAFT WAS GUIDE SHAFT AND DIMM. 69 WAS 66. K.P. 29/11	25-6-99	JWM/FDD AWM/DO
INDEX	ALTERATION	DATE	SIGN
		24-4-99	66/
DRN	TCD	CKD	JWM/TDO
			JWM/PR
			WM/HT
			AWM/TPE
			APPD
FORGING DRAWING			REF. DRG. No.
(A) DRIVE GUIDE SHAFT			1:1 SCALE
L P T A - 713, A G B			M/C
M/S TELCO. LTD.			T.D.O
VEHICLE-FACTORY JBP.			SECTION
DRG. NO. 322 283 0605-3			21-4-99 DATE
			DEMANDED BY
			1/1 SHEET
			CHANGE NO (R)